

Work Order ID 105255

105255

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Tuesday, July 30, 2013 4:25:36 PM

Item ID: D2596

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web, 205 Skidtube

Start Date: 7/30/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/1/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date: 13-07-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2596

Rev D

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- 1- Cut D2500-3-100 to length: 99.5"
- 2- Use Jig DT8093 to drill pilot holes #30
- 3- Open to 0.630" diameter as per Dwg D2596
- 4- Deburr

110

Chemical Conversion Coat per QSI005 A.1

0.00

110

HandFinish

Memo

0.00

Hand Finishing

120

QC5: Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

J.D.
SAD

J.D.
SAD

13/08/13

13/08/13

4

13/08/13



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Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours |
|--------------------------------|--|----------------------|
| 130 | Identify as per dwg & Stock Location <u>LL</u> | 0.00 |
| *130* | | |
| Packaging | Memo | 0.00 |
| Packaging | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 |
| *140* | | |
| QC | Memo | 0.00 |
| Quality Control | | |

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|--------------|---------------|---------------|------------------|----------------|
|---------|--------|--------------|---------------|---------------|------------------|----------------|

43.8/08/14M.L.S 13-8-15QC 13.8.14

Picklist Print

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Work Order ID: 105255

105255

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 7/30/2013

Required Date: 8/1/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2500-3-100 | | Manufactured | No | | | 100 | Each | 116.0000 | 1 | 4 | | | |
| *D2500-3-100* | | | | | | | | | ** | | | | |
| Ext'n -1' Beam Web 4" | | | | | | | | | | | | | |

Location

LG

84873

89110

Loc Qty

116

4

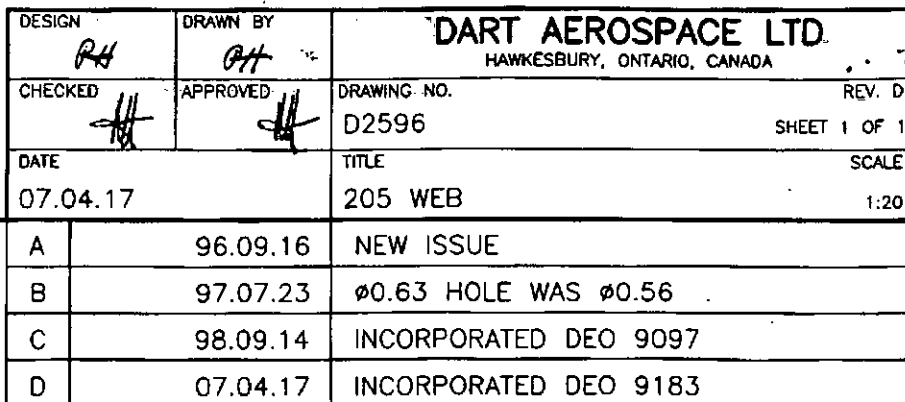
112

Loc Code

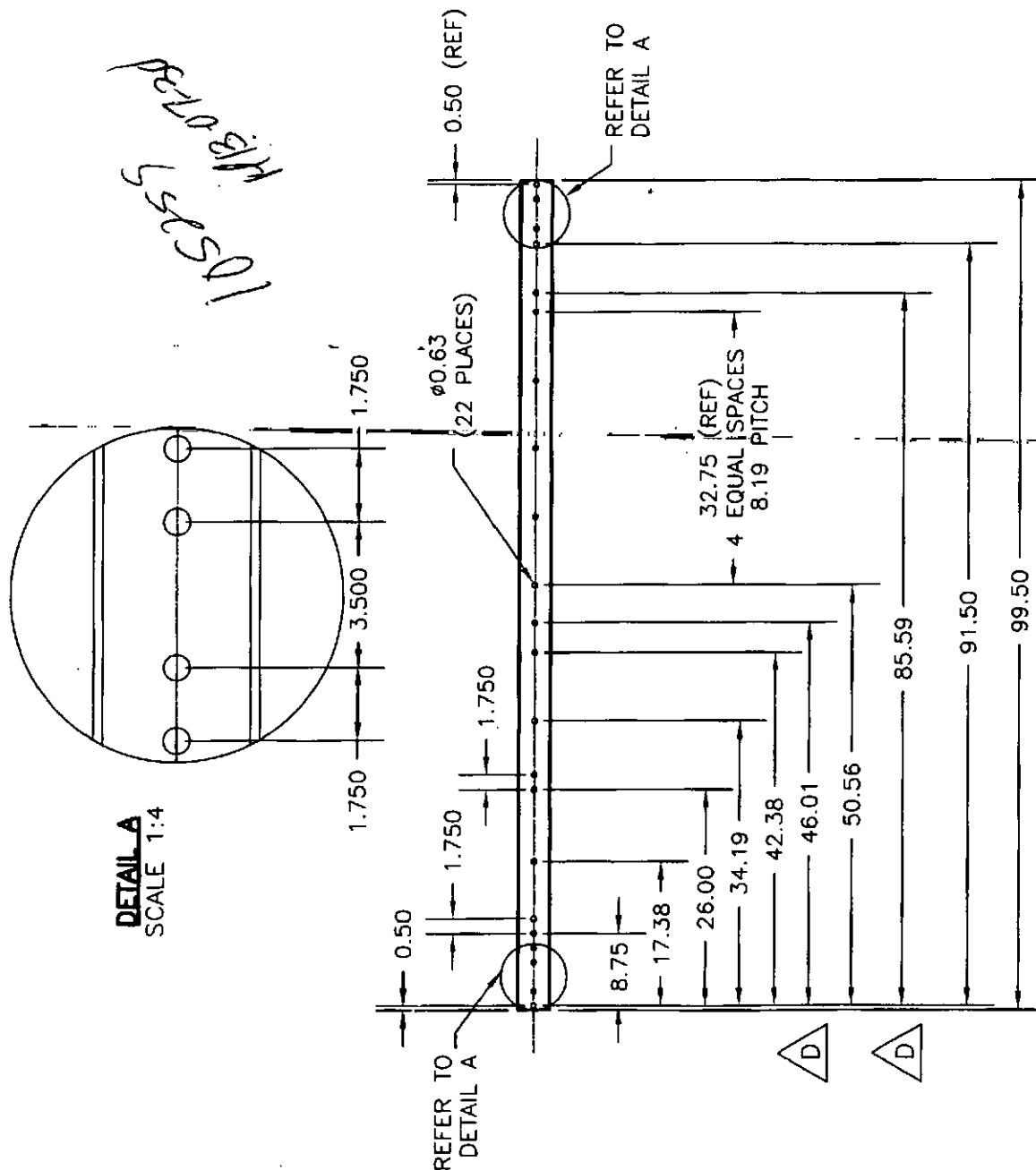
④

J-D
SAD

13/08/13



RELEASED
07 DEC 28



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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